Work Order ID 95367 Page 1 January-09-13 11:23:39 AM Item ID: D3262-043 Accept *N900040100* **Revision ID:** Canister Assembly Item Name: 1/15/13 **Start Date:** Start Qty: 1.00 **Cust Item ID: Req'd Qty:** 1.00 Required Date: 1/25/13 **Customer:** Reference: Run Process Plan: MC5 Date: 13-01-10 Tooling: Approvals: Stop QC: _____ Date: ____ SPC (Y/N): _____ Date: _____ Reject Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Insp. Number Stamp Work Center ID Description **Run Hours** Code **Qty Qty** Draw Nbr **Revision Nbr** D3262 Weld per dwg A/R Aluminum rod Batch: 123528 100 Large Fab *100* Large Fab 0.00 Memo Large Fab Weld canister assembly as per Dwg D3262 using DT8739 to align fittings 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *110* 1) 13-01-24 0.00 Memo Quality Control QC5- Inspect part completeness to step on W/O 120 0.00 *120* D-13-01-24

0.00

Memo

Pressure test as per Dwg D3262

QC

Quality Control

												DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORI	MANCE / UI	PDATE		·		
												QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS	
Work ord	C1.					Rework	7		Skid-tube	Crosstube		1	Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	-	Proc	d. Eng. Coor.	Quality
						Use-as-is	1	Į.	noforming	Finishing		1	e/Packaging	Other
NCR	No.					Work Order Update]		Large Fab	Composite			Supplier	
			1		r		T .	<u> </u>					 	1
Root					i .	ption of work order update		Initial		ction		Sign &		
Cause	_	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Des	cription		Date	Verification	QC Inspector
Doc/Data			j			• • •								
Equip/Tooling	L								•					
Operator	L													
Material					•	at the second se								
Setup														
Other	L		1		•									
Process			,											
Supplier														
Training	L													
Unapproved			<u> </u>											
						F	AUL	LT CATE	GORY					
Land	ing (Gear		,		General								-
		Bending				Bend		Grain				Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Г	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	rt -	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

DOA:

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion *

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 95367 *95367* Page 2 January-09-13 11:23:39 AM Item ID: D3262-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Canister Assembly Start Date: 1/15/13 Start Otv: 1.00 Cust Item ID: Required Date: 1/25/13 **Reg'd Oty:** 1.00 Customer: Reference: Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. Otv Number Stamp **Work Center ID** Code **Description** Run Hours Otv 130 Chemical Conversion Coat per OSI005 4.1 0.00 *120* HandFinish 0.00 Memo Hand Finishing 140 White Gloss(Ref. 4.3.5.1) per QSI005 4.3-Alum 0.00 1 & \$ 13-128. *140* Powdercoat 0.00 Memo Powder Coating ****Ensure to mask threads, **** START TIME: **OVEN TEMPERATU** FINISH TIME:

150

OC3-Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

											DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UPDATE					
											QA Closed:	Da	ate:	
Work Orde	er.					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS		
Part I	No.				· · · · · · · · · · · · · · · · · · ·	Rework Scrap Use-as-is Work Order Update		1	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
l New 1	10.					Work Order opuate	J		carge rab	<u> </u>	J	Jupplier	ш	
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verificatio	'n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						r								
ļ 							AUL	T CATE	GORY					
Landi	$\overline{}$					General	_	1.		_	7		_	1
		Bending Centre No Cracks Crushed/ Cuffs	Crimped.		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct Mainte	ion Incomplete ions Incomplete/Unclear enance		Ovalized Over/Under Part Incorred Part Lost/Mil Part Moved	ct ssing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	1 1	Heat Trea	it		I	Countersink	1	Mislabe	eled	1	Positioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 95367

Quality Control

95367

Page 3

January-09-13 11:23:39 AM Item ID: D3262-043 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Canister Assembly **Start Date:** 1/15/13 Start Oty: 1.00 **Cust Item ID:** Required Date: 1/25/13 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start **Tooling: Approvals:** Process Plan: Date: Date: Stop Date:_____ SPC (Y/N): Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Number Stamp Qty Work Center ID Description **Run Hours** Code Identify as per dwg & Stock Location: 0.00 160 *160* Packaging 0.00 Memo Packaging QC21- Final Inspection - Work Order Release 0.00 170 *170* 0.00 Memo

pl(3-01-30

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	es , 140								QA Closed:	Date	:	
Work Orde	r·				DISPOSITION		,	AGAINST DE	PARTMENT,	/PROCESS		
Part N					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Engineering Prod. Eng. Coor. Quality		
NCR N	o				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite				
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data												
quip/Tooling												
Operator		ł			•							
Material			!									
Setup												
Other												
Process												
Supplier	,											
Training												
Jnapproved												
					F	AULT CATE	GORY					
Landin	g Gear				General		-		_		<u> </u>	
	Bending				Bend	Grain			Ovalized		Pressure/Forced	
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
. [Cuffs				Contamination	Maint	enance		Part Moved		_	
ſ	Heat Trea	it			Countersink	Mislab	eled		Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	'Surge	Other	
	Ripples in	Bend			Drill Holes	Offset		Name of the last o	-			
	Torque W	aves in E	xtrusio	n $lacksquare$	Drawing	Out of	Calibration					
Γ	Turning S	equence			Finish	Out of	Sequence					
	Wave/Tw	rist in Tub	oe .		Folio	Outsid	e Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-09-13 11:23:39 AM

Work Order ID:

95367

Parent Item:

D3262-043

Parent Item Name:

Canister Assembly

Start Date: 1/15/13

Required Date: 1/25/13

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP rev A 10.01.19 new issue EC verified by: DD

IPP Rev:B as per ECN10-571 DD

10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Status Issued Issued
D3262-1 Tube		Manufactured	No	B-426	94.7	100	Each	0.0000	1	1	St 13.01.23
D3262-5 Cap		Manufactured	No	B919	112 1	100	Each	7.0000	2	2	DE 13.01.23
				Location		Loc Qty	<u>Lo</u>	c Code			

 Location
 Loc Qty
 Loc Code

 LG002
 7

 74724
 1

 86708
 6

NCR:	Yes	1	Nο

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORI	MANCE / UPDATE				
												QA Closed:	Date:	
Vork Ord	er:						DISPOSITION			AC	GAINST DEI	PARTMENT	PROCESS	
Part							Rework Scrap Use-as-is			Machining Sm	osstube nall Fab		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	No.						Work Order Update			· —	nposite	·	Supplier	
Root					Desc	crip	tion of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Description	1	Date	Verification	QC Inspector
oc/Data									:					
uip/Tooling							,	*:						
perator							· .							
laterial														
etup	_									÷				
ther	L													
rocess	L													
upplier]												
raining									•	`. *				
napproved														
							F.	AUL	T CATE	GORY				
Land	ing (Gear			_		General					-		_
		Bending					Bend		Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to (o/s [BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			[Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped.		[Burrs		Instruct	ions Incomplete/Unclea	r 🗌	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			Ţ		Contamination		Mainte	enance		Part Moved		
		Heat Trea	it		Ī		Countersink		Mislabe	eled.		Positioned V	Vrong	_
		Inspection	n Strip in	Tube	Ī		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples in	Bend		İ		Drill Holes		Offset	-		-		
		Torque W	/aves in E	xtrusion	,		Drawing		Out of	Calibration				
	Г	Turning S	equence		Ī		Finish		Out of s	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

SHOP COPY

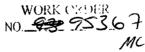
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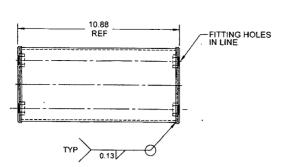
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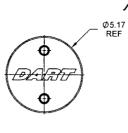
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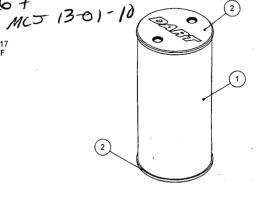
SUBJECT TO AMENDMENT

WITHOUT RODICE









D3262-041 CANISTER ASSEMBLY



	ε	0.25 WAS 0.45 (ZNC7-4 5); ADD DIMENSION (Z	, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7- N B1-4, D1-5, B1-5)	RF	10.05.03
	D	ADD D3262-043/-5 (ZN 1 TO EQUAL TOOL DIME 09-004	B5-2; B5-5); REVISE DIMENSIONS NSIONS (ZN B2-4; C2-4) PER CAR	RF	09.12.30
No	С	Ø5.165 WAS Ø5.19	90	RF	06.08.31
NOTES: 1) MATERIAL: N/A	В	ADD PRESSURE TE	STING OPTION	MB	05.02.14
2) FINSH: CHEMICAL CONVERSION COAT PER QSI 005 4.1	А	NEW ISSUE		RF	04.05.06
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3	REV.		DESCRIPTION	BY	DATE
4) UNITS: INCHES UNLESS OTHERWISE NOTED	DESIG		DART AEROSPA	ACE L	(D
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX	DRAW	N RF	HAWKESBURY, ONTAR	O CANA	JA
	CHECK	ED A	DRAWING NO.	,	REV. E
7) WEIGHT: 2.51 lbs	MFG. A	PPR.	D3262		SHEET 1 OF 5

HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 1 OF 5 APPROVED TITLE SCALE DE APPR. **FUEL PURGE CANISTER**

DATE 10.05.03

8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

3

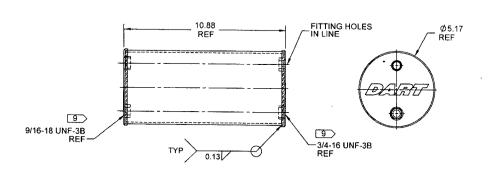
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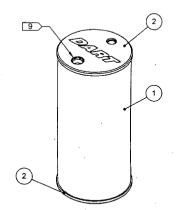
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C

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ITEM	QTY -043	P/N	DESCRIPTION
	Х	D3262-043	CANISTER ASSEMBLY
1		D3262-1	TUBE
2	2	D3262-5 .	CAP



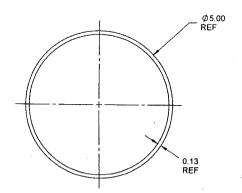


D3262-043 CANISTER ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 lbs (6) IDENTIFICATION: IDENTIFY WITH DAKT P/N D3262-043" AND B/N USING FINE POINT 1) WEIGHT: 2.50 lbs
 (7) WEIGHT: 2.50 lbs
 (8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
 (9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LT	D
DRAWN	RF	HAWKESBURY, ONTARIO, CANAD	_
CHECKED	1	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 2 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	-#	FUEL PURGE CANISTER	NTS
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE I THE BOOLARH IS PRIVATE AND COMPRIME AND IS SUPPLED ON THE EXPRESS ON NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER WESTED FERMISSION FROM DAY A SENDENCE LTD	CONDITION THAT IT IS

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D3262-1 TUBE



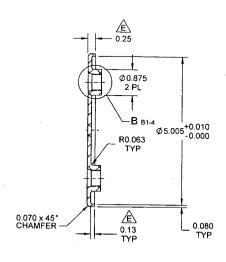
NOTES: 1) MATÉRIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125

REF. DART SPEC. M60611615.000W.125
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESC. OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.96 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

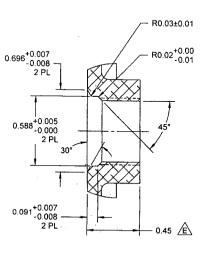
DESIGN	RF	DART AEROSPACE	ITD
DRAWN	RF	HAWKESBURY, ONTARIO, CAN	
CHECKED	\$	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 3 OF 5
APPROVED	NP	TITLE	SCALE
DE APPR.	-#	FUEL PURGE CANISTER	NTS
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPAG THIS DOCUMENT IS PRIVATE AND COMPRESHING, AND IS SUPPLIED ON THE CHYRI NOT TO BE USED FOR ANY PURPOSE OR COMPLED OR COMMUNICATED TO ANY O	85 CONDITION THAT IT IS

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DRILL THRU Ø0.516 (33/64 DRILL), TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 Ø5.165 RFF 1.63 3.25 REF 6



DETAIL B C7-4

SECTION A-A C5-4

D3262-3 CAP

NOTES.

1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.28 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE

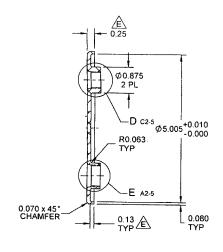
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.S.	DRAWING NO.	REV. E
MFG. APPR.	91	D3262	SHEET 4 OF 5
APPROVED	149	TITLE	SCALE
DE APPR.	-41-	FUEL PURGE CANISTER	NTS
DATE 10.05.03		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIMATE AND COMPRISHMENT, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PROPOSED OR COMPANDATED TO ANY OTHER PERSON WITHOUT	

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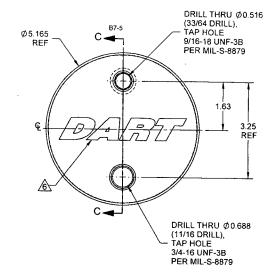
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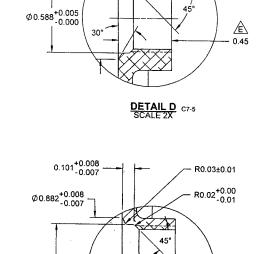
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SECTION C-C D5-5



D3262-5 CAP



2 .

R0.03±0.01

R0.02^{+0.00}_{-0.01}

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DETAIL E B7-5 SCALE 2X

£ 0.45

DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE FUEL PURGE CANISTER DE APPR. NTS

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

REF. DART SPEC. M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SH/. 7P EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP

(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN

7) WEIGHT: 0.27 lbs

8) PART IS SYMMETRICAL ABOUT CENTERLINE

3

3

0.091+0.007 -0.008

Ø0.696^{+0.007}

Ø0.771+0.005 -0.000

DATE

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10.05.03

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